

5/46

ASJ 140

DART AEROSPACE LTD	Work Order:	24672
Description: Forward Cap	Part Number:	D2744
Drawing: D2744 Rev. B1	Qty:	45 50
RF 04.03.10		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller 6.650"	JA	05.10.26	50
2	MV	Cut blanks: (6.400" x 3.125") Material: 5052-H32 (QQ-A-250/8) or 6061-T6 (QQ-A-250/11) 0.080 thick. Use off-cuts (M5052H32S.080) Batch M18710	SD	05.11.07	50
3	MV	Machine per Folio FA309 and Dwg D2744	SD	05.11.07	45
4	QC2	Inspect parts as they come off the CNC machine	SD	05.11.07	45
5	MV	Deburr			
6	QC8	Inspect 100% for completeness on the W/O	Ep	05/11/08	45
7	LG	Identify and Stock	CD	05/11/08	45
8	AC	Cost / part 3.41	SAC	05-11-10	45
9	DC	Close W/O 2.85 Inspect Level 21			

P90

Rev	Date	Change	Revised By	Approved
A	98.09.10	New Issue	DS/CP	
B	98.12.07	Added off-cuts	DM	
C	03.01.17	Reformat; Dwg revised	KJ/RF	JA

MIS only

RELEASED
03.01.23 RFUNDER REVIEW
04.02.02 RF

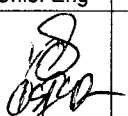
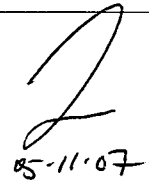

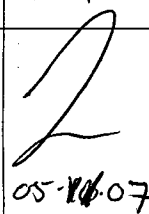
CANCEL RF 04.03.10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		Please Remove Step #5					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05.11.07	3	stack moved while machining 5 parts badly damaged		Scrap 5 no replace.	SA 05.11.07	 05.11.07		 05.11.07

NOTE: Date & initial all entries



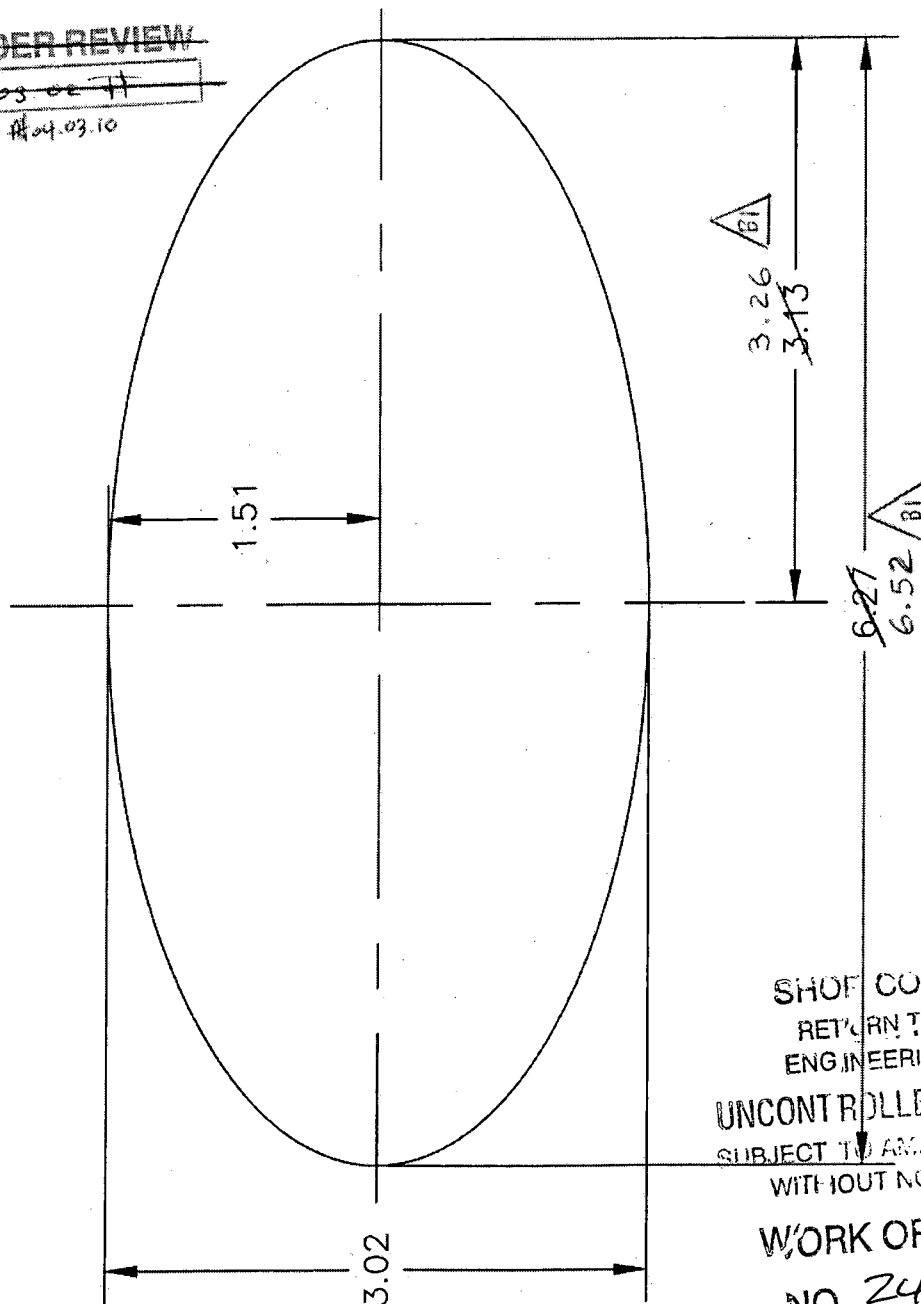
DESIGN <i>HH</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>HH</i>	APPROVED <i>HH</i>	DRAWING NO. D2744	REV. B SHEET 1 OF 1
DATE 02.12.18		TITLE CAP	SCALE 1:1
A	98.04.16	NEW ISSUE	
B	02.12.18	REDESIGN	
Bi	<i>HH</i> 04.03.10	6.52 WAS 6.27; 3.26 WAS 3.13	

RELEASED
02.12.18 *HH*

UNDER REVIEW

04.03.02 *HH*

OK *HH* 04.03.10



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 24672

NOTES

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) OR 5052-H32 (QQ-A-250/8), 0.080 THICK (REF. DART SPEC M6061T6S.080 OR M5052H32S.080)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 25, 2005
04:04 pm

Work Order No : 0024672
Project Name : D2744
Project For : WK546
Work Order Type : Main
Main WO Number :
House Part Number : D2744
Description : Fwd Cap
Manufactured : Yes
Amount Req'd : 50
Amount Done : 0
Start Date : 10-25-05
Est Finish Date : 11-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
12:44 pm

Work Order No : 0024672
Project Name : D2744
Project For : WK546
Work Order Type : Main
Main WO Number :
House Part Number : D2744
Description : Fwd Cap
Manufactured : Yes
Amount Req'd : 50
Amount Done : 0
Start Date : 10-25-05
Est Finish Date : 11-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00